

lugs on the interior of the casting prevented the work from being held in a three-jaw chuck, on account of interferences with the jaws. A two-jaw chuck was, therefore, utilized, and interferences thereby avoided. As the centering action of a chuck of this type is very uncertain when used for holding work by an interior surface of comparatively large diameter, some method of locating was necessary which would at the same time center the casting, and yet not cause trouble by interfering with the lugs on the interior of the flywheel. (The lugs on the interior of the casting are not shown in the illustration, in order to avoid confusion.) The chuck body *B* is screwed to the spindle *C* in the usual

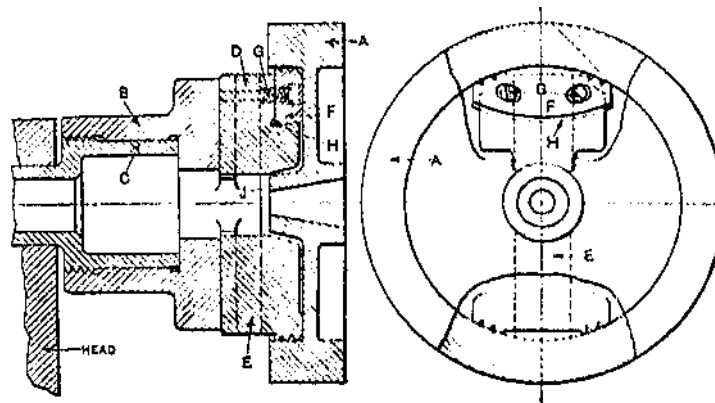


Fig. 7. Two-jawed
Chuck arranged with a
Floating Jaw

manner and is provided with two special jaws, one of which, *F*, is of plain design having two bearing surfaces on the inner rim of the flywheel casting. The other, *G*, *H* grooved to fit the chuck like the regular jaw

but is very much wider as it comes above the face of the chuck. This portion is turned to a radius at H and given an angle of 10 degrees at the same time in order to counteract the lifting tendency which might cause trouble when the jaws were tightened. The floating member or " * rocker " F is mounted on this jaw as shown in the illustration, and is limited in its movement by the two screws 6* and the elongated holes in the rocker. This construction gives a very good center-